










Date: Monday, 18/09/2006 11:36:05 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 28630		
Estimate Number	: 12529		
P.O. Number	: N/A	Part Number	: D35571
This Issue	: 18/09/2006 S.O. No. : N/A	Drawing Number	: D3557 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL / MED FAB	Drawing Revision	: U/R
Previous Run	: N/A	Material	: p/a
Written By	:	Due Date	: 25/09/2006 Qty: 5 Um: Each
Checked & Approved By	:		
Comment	: Est Rev: New Issue 06-09-18 JLM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S125	2024-T3 .125 sheet	
			
Comment: Qty.: 0.0360 sf(s)/Unit Total : 0.1801 sf(s) 2024-T3 .125 Sheet (M2024T3S0125) Batch: <u>1102087</u> <i>06 09 19</i>			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET 1-Cut as per Dwg D3557 Dwg Rev: <u>Pre1</u> Prog Rev: <u>Pre1</u> ****Ensure Grain Direction is Correct**** 2-Deburr if necessary <i>06 09 19</i>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>06 09 19</i>			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <i>06.06.19</i>			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 06/10/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/09/2006 11:36:05 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 28630

Part Number: D35571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3557

SB 04/03/25 (5)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-09-25 (5)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

06-10-02 a.m. 06-10-02 (5)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

9.m 06-10-02 (5)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PU 6/10/03 (5)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57448

PO 6/10/03 (5)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/03 (5)

Job Completion



U 06-10-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

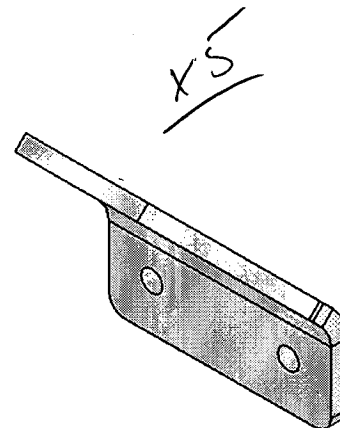
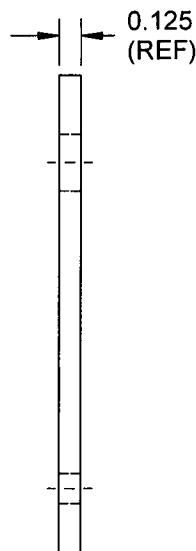
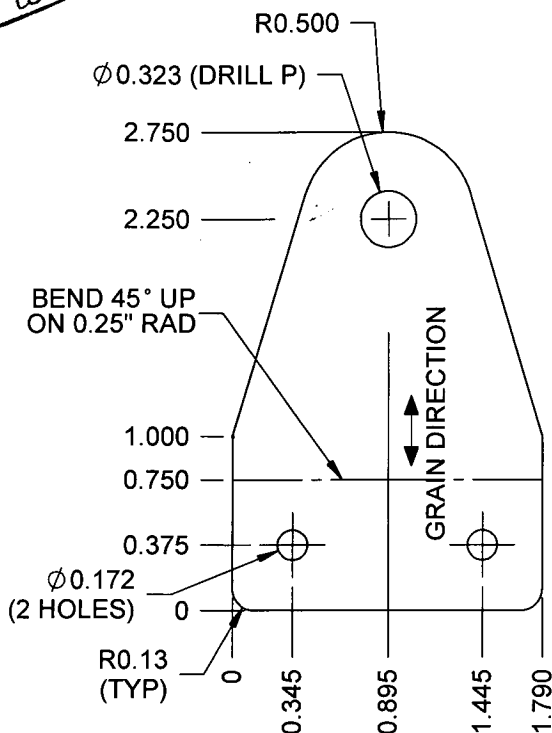
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

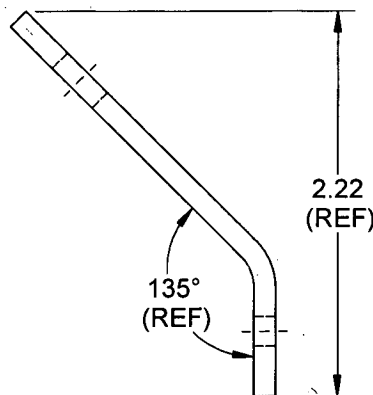
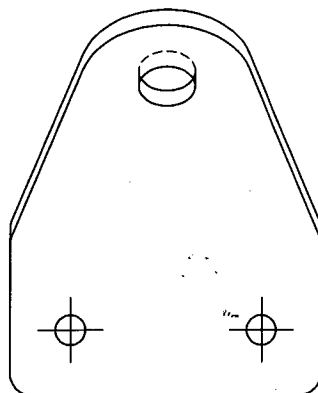
PRELIMINARY ISSUE

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED	DRAWING NO. D3557	REV. A SHEET 1 OF 1
DATE 06.09.15	TITLE BRACKET		SCALE 1:1
REV A	DATE 06.09.15	DESCRIPTION NEW ISSUE	

UNDER REVIEW
06.09.15 *LE*



D3557-1F FLAT PATTERN



D3557-1 BRACKET

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM 0.125 THICK (REF DART SPEC M2024T3S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.5.3.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

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D INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

I hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the requirements described therein, including any specifications forming a part of the description and that samples of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

624188 0
Ship Date B.L. No. Invoice No. Alcoa No. Item
 2006-06-22 1567488 00000 1841748-1
P.O. No./Govt Contract No. Customer Mfg Order
 CI9208 C&B DS-94537-1

Page 1

Mark J. Vrabec
 Manufacturing Davenport Works

Kenton P. Young
 Quality Assurance Manager

COPPER BRASS SALES
 415 STATE PARKWAY
 SCHAUMBURG, IL 60195

Item Description
 1250 IN TK X 48.000 IN W X 144.000 IN LN CAT D 126185 (N) A/T 2024-
 E3 FLAT SHEET MILL FINISH {{ P/N 061913-0 }}. PER AMS-QQ-A-
 250/4 REV A & (EXCEPT OIL &
 MARKING) AMS4037 REV N & (EXCEPT MARKING)
 ASTM B209 REV 04 ((MARKED)) INTERLEAVED SKID
 WGT: 4500 LB QUAN TOL +/-10 %
 CQR D126185 REV 27 QRR 003140 CUST REQ 06-05-
 07 *** W/E 06-05-13 ***

Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl
021	327373	1877	22	PC	

CQR: D126185.27

PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/4 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/4E, AMENDMENT 2.
 PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/4E AMENDMENT 2 ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/4.

126185.27 -Specification Limits -----

	UTS	TYS	EL4D										
	KSI	KSI	PCT										
Max	63.0	42.0	15										
Min													
Composition	SI	FE	CU	MN	MG	CR	ZN	TI	Each	Total	Aluminum		
Max	.50	.50	4.9	.9	1.8	.10	.25	.15	.05	.15			
Min			3.8	.30	1.2						REMAIN		

327373 -Mechanical, Physical, Metallography, Quantometer Results -----

No.	UTS	TYS	EL4D
Test	KSI	KSI	PCT
Max	67.3	47.4	19.1
Min	66.7	47.2	18.2

INSPECTION REPORT

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2006-06-22

1567488

00000

1841748-1

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C&B

DS-94537-1

Mark J. Vrabec
Manufacturing Davenport Works

Kenton P. Young
Quality Assurance Manager

27373 - Mechanical, Physical, Metallograpy, Quantometer Results (cont.) -----
er Chemical SI FE CU MN MG CR ZN TI
Actuals .07 .16 4.7 .64 1.5 .00 .10 .03

COPPER AND BRASS SALES

SOLD TO: C & B

DATE: 9/18/12

CUSTOMER PO: 0000195

SHIPPER NO: 420648

BY: [Signature]